

Work Order ID 87427

July-11-12 11:37:38 AM

ASMO
87427

Page 1

Item ID: D3694-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: MOUNTING PLATE
 Start Date: 7/10/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3694	Rev C								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D36942-Install Protective & Mounting plate as per Dwg D3694

12/07/12

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS 16 12/07/12

4

120

Identify as per dwg & Stock Location *5255*

0.00

120

Packaging

Memo

0.00

Packaging

12-7-B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CK 12/7/13

MF

12-07-13

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Picklist Print

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Work Order ID: 87427

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM
IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R8 Screw		Purchased	No				Each	548.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST348		548							
				9216		548							
AN960JD10 Washer	NAS1149D0363J	Purchased	No				Each	0.0000		10		7/12/07/12	
D3694-1 Mounting Plate		Manufactured	No				Each	1.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		1							
				56906		1							
D3694-3 MOUNTING PLATE ASSY		Manufactured	No				Each	7.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		7							
				56907		7							
D3694-5 MOUNTING PLATE ASSY		Manufactured	No				Each	8.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		8							
				56908		8							

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Work Order ID: 87427

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No Each 3,199.0000

8

Nut

Location Loc Qty Loc Code

ST300 1199

117885 32

119017 763

119075 138

121444 266

ST317 2000

122141 2000

MS21209-F120 Purchased No Each 125.0000

4

HELI COIL

Location Loc Qty Loc Code

ST304 125

114037 29

121709 96

MS24693-C271 Purchased No Each 5,529.0000

2

Screw

Location Loc Qty Loc Code

ST310 5529

1112 3735

1139 1183

1445 383

1664 228

MS24693-C273 Purchased No Each 53.0000

8

Screw

Location Loc Qty Loc Code

ST310 53

120308 25

121060 28

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Shop Packet Print

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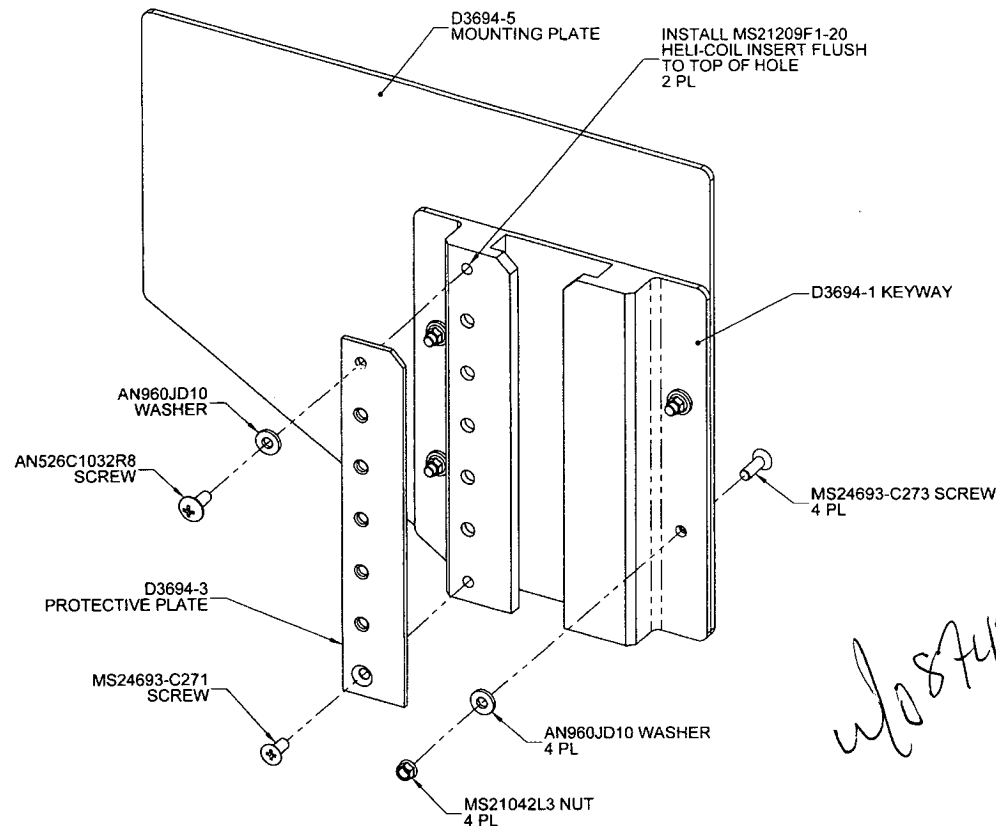
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D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

RELEASED
09/12/05/MB

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13: UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY: 1 MS24693-C271 SCREW WAS QTY: 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C
SHEET 1 OF 4
TITLE **MOUNTING PLATE ASSY** SCALE NTS

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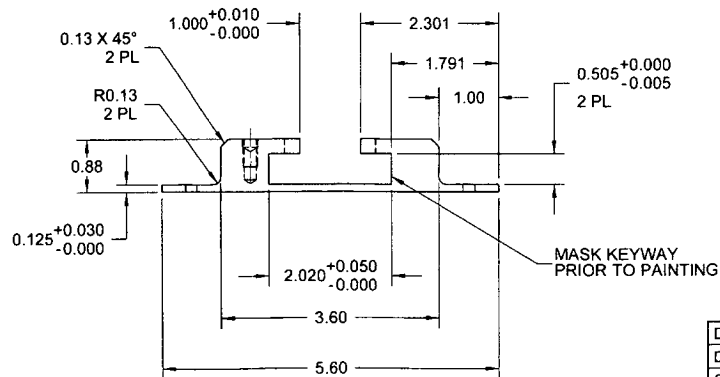
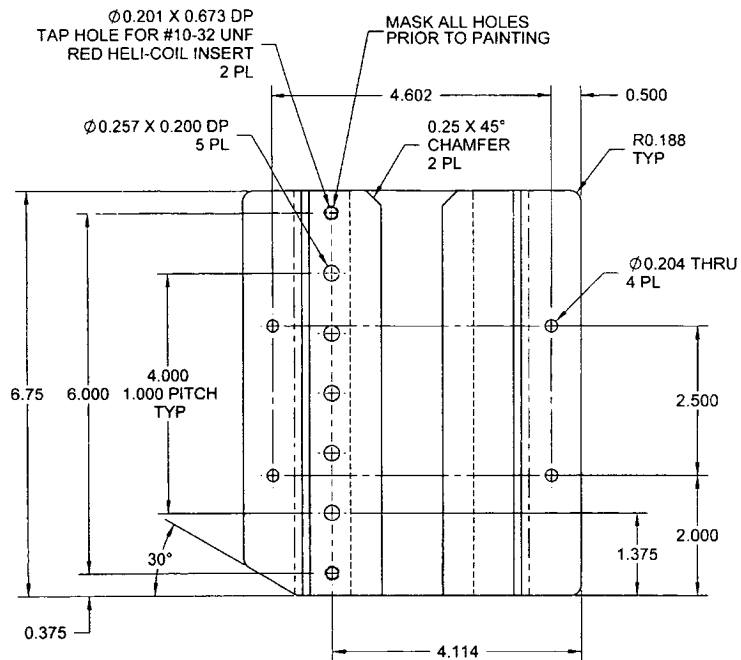
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NOTE: Date & initial all entries



D3694-1 KEYWAY

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

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MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
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RELEASED
09/06/05

Dart Aerospace Ltd

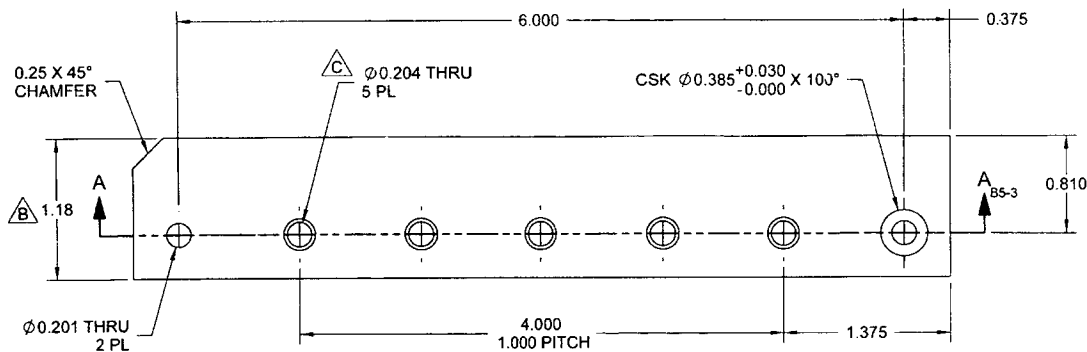
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

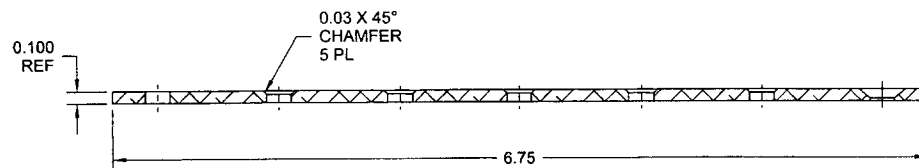
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D3694-3 PROTECTIVE PLATE



SECTION A-A

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

RELEASED
07/26/05

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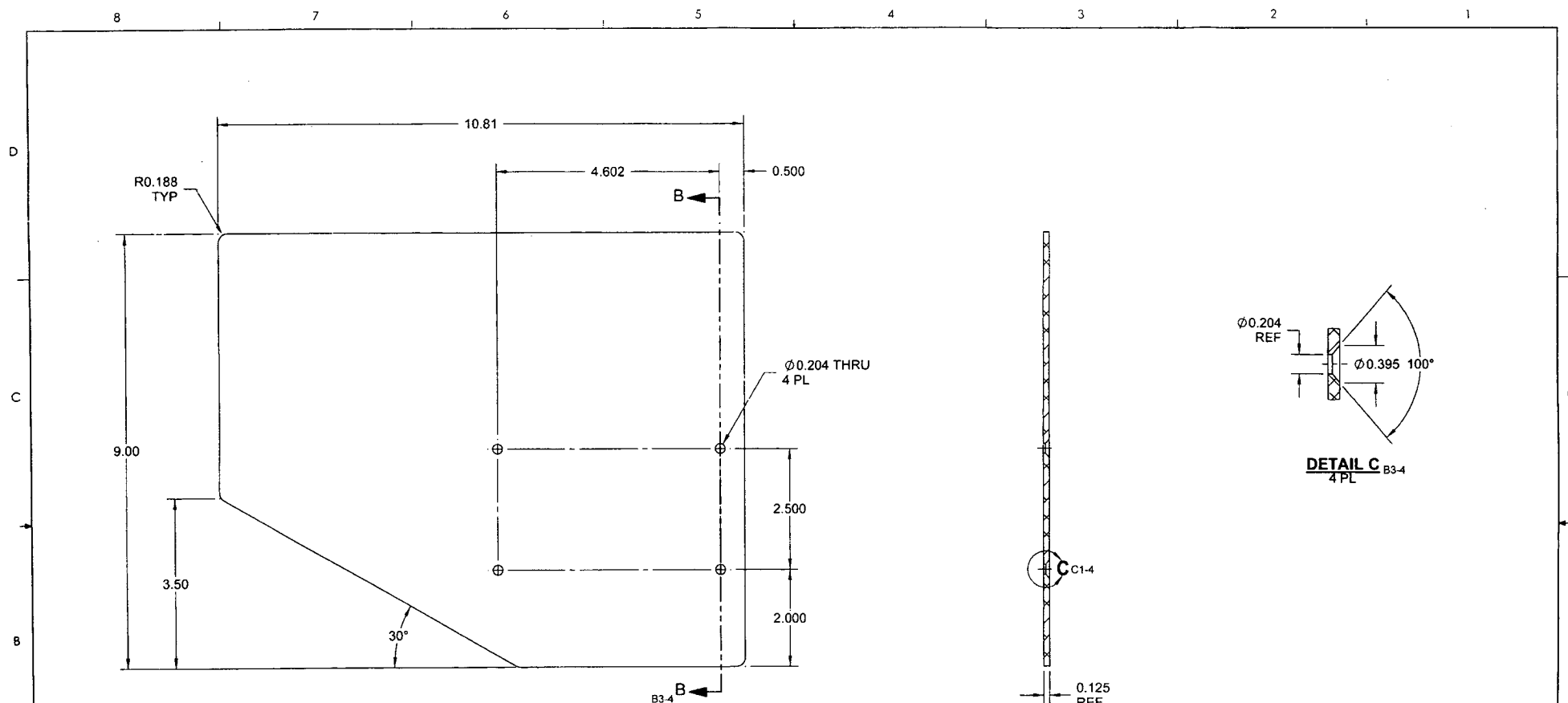
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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

RELEASED
6/9/05

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

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